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D206-667-147TRN
Job Sheet 168214-B



Part No: D206-667-147TRN

Job Qty: 1 ea

Part Name: Crosstube Assembly, Mid Fwd



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/13/17

Job Tracking No:

Due Date: 11/30/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV A IPP rev:A 11.01.06 new issue DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/29/17	0.00	0.00	Start Up Crosstubes		PMP
100	Mori Seiki	1 pcs		11/29/17	3.21	1.47	Mori Seiki TL-40		PMP
110	QC	1 pcs		11/29/17	0.00	0.00	QC2		PMP
120	Mori Seiki	1 pcs		11/29/17	0.00	1.47	Mori Seiki TL-40		PMP
130	QC	1 pcs		11/29/17	0.00	0.00	QC2		PMP
140	QC	1 pcs		11/29/17	0.00	0.00	QC8		PMP
145	Crosstubes	1 pcs		11/29/17	0.00	0.25	Crosstube		GP
150	HandFXtube	1 pcs		11/30/17	0.00	0.13	Crosstube		SA 11-05-10
160	QC	1 pcs		11/30/17	0.00	0.00	QC7		DPZ
170	Packaging	1 pcs		11/30/17	0.00	0.00	Packaging3		DPZ
180	QC21-SA	1 Ea		11/30/17	0.00	0.00	QC21		DPZ OCT 03 2018

Part Op 100 - 1-Fill tube with sand & install plugs 206-147 on both ends as per Folio FB029 2-Turn first side as per Folio FB029
Descriptions: 3-Blend transition lines only with belt sander 60 grit.

120 - 1-Turn second side as per Folio FB029 2-Blend transition lines only with belt sander 60 grit.

145 - GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.

150 - 1- handfinish X-TUBE INSIDE AND OUT

170 - LOCATION : LG014

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D6002-115	1	88	0	0

B107867

Part Specifications

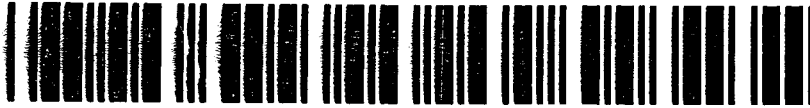
Specifications could not be found.

Plex 11/13/17 12:43 PM dart.poulin.mario

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Crosstube Assembly, Mid Fwd

PART NO: D206-667-147TRN

Revision:

Operation: Start up Operation

Change No:

Mfg Date: 11/23/17

Job No: 168214-B

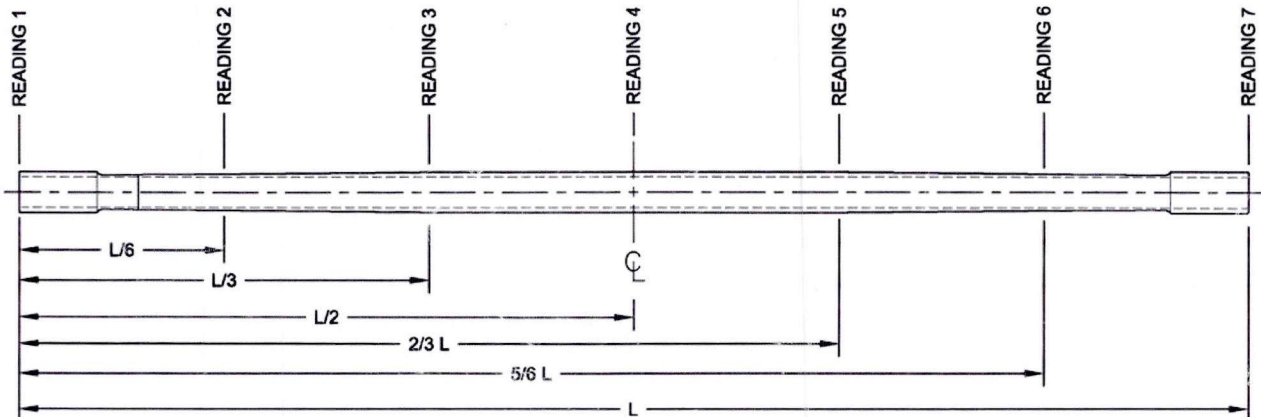
DART AEROSPACE LTD	Work Order:	168214-B
Description: Crosstube Assembly, Mid Fwd	Part Number:	D206-667-147
Inspection Dwg: D206-667-147 Rev: A		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.242	✓		VERN 08	
	1.984	+0.005/-0.000	1.986	✓			
	2.019	+0.005/-0.000	2.0225	✓			
	2.058	+0.005/-0.000	2.0625	✓			
	2.097	+0.005/-0.000	2.1015	✓			
	2.136	+0.005/-0.000	2.140	✓			
	2.176	+0.005/-0.000	2.1795	✓			
	0.125	+/-0.010	.125	✓		VERN 08	
	R0.063	+/-0.010	.063	✓		RG	
	R2.00	+/-0.010	2.0	✓		RG	
	R0.063	+/-0.010	.063	✓		RG	
	4.438	+/-0.030	4.43	✓		VERN 08	
SIDE B	2.240	+0.005/-0.000	2.243	✓		VERN 08	
	1.984	+0.005/-0.000	1.988	✓			
	2.019	+0.005/-0.000	2.023	✓			
	2.058	+0.005/-0.000	2.0625	✓			
	2.097	+0.005/-0.000	2.1015	✓			
	2.136	+0.005/-0.000	2.1405	✓			
	2.176	+0.005/-0.000	2.1805	✓			
	0.125	+/-0.010	.125	✓		VERN 08	
	R0.063	+/-0.010	.063	✓		RG	
	R2.00	+/-0.010	2.0	✓		RG	
	R0.063	+/-0.010	.063	✓		RG	
	4.438	+/-0.030	4.438	✓		VERN 08	
	99.84	+/-0.020	99.84	✓		TAPE	

DART AEROSPACE LTD	Work Order:	
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WALL THICKNESS MEASUREMENT



Location	WALL THICKNESS MEASUREMENT (IN)				Deviation Δw (max-min)	TOLERANCE
	w1	w2	w3	w4		
READING 1 L= 0"	240	248	254	254	.014	0.035"
READING 2 L= 16.64	166	165	169	172	.007	
READING 3 L= 33.28	244	246	250	249	.006	
READING 4 L= 49.92	245	250	258	256	.013	
READING 5 L= 66.56	243	250	252	249	.009	
READING 6 L= 83.2	168	168	165	174	.009	
READING 7 L= 99.84	246	248	254	257	.011	

Calibration Result

Actual Block Thickness: 100-300

Sitiescan 250 Measured Thickness: 100-300

Measured by:	PMP
Date:	2017-11-21

Audited by:	[Signature]
Date:	18-02-20

Preliminary Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
B	11.06.21	New Issue	KJ	
C	12.06.04	Wall thickness form added	KJ	